

Date: Thursday, 10/18/2007 8:04:21 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	35227	Part Number	D29322UP
Estimate Number	12930	Drawing Number	D2932 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	10/18/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	MACHINED PARTS
First Issue	N/A	Material	N/A
Previous Run	34730	Due Date	11/5/2007
Written By			
Checked & Approved By	HJ 07.10.18		
Comment	Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101003	<p>7075-T7351 2X6.25X7.875</p> <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: B 34644</p>
2.0	HAAS1	<p>HAAS CNC VERTICAL MACHINING #1</p> <p>Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. ✓ 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr</p> <p>SA 07.11.19</p>
3.0	MILLING CONV.	<p>CONVENTIONAL MILLING MACHINE</p> <p>Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet</p> <p>✓ 07.11.21 (8)</p>
4.0	QC1	<p>INSPECT ALL DIM TO DIM SHEET</p> <p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p>✓ 07.11.19</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:04:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 35227

Part Number: D29322UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28 07/11/23 (8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/11/26 (8)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

6/14/28 (8)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

445

6/14/28 (8)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/14/28 (8)

Job Completion



6/14/28 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	35227
Description: 206 Saddle, Outboard, Right side			Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.118	.119	.120		
B	0.100	0.140		.116	.119	.121	.118		
C	0.100	0.140		.117	.120	.119	.117		
D	0.210	0.230		.221	.220	.220	.221		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.251	1.250	1.248		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.578	1.578	1.577	1.577		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.115	.122	.122	.122		
O	0.540	0.560		.552	.549	.548	.546		
P	0.490	0.510		.498	.500	.500	.495		
Q	3.715	3.725		3.719	3.718	3.719	3.719		
R	2.470	2.510		2.494	2.492	2.492	2.493		
S	0.240	0.270		.249	.251	.253	.253		
T	0.100	0.180		.145	.185	.185	.145		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.369	1.367	1.368	1.369		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.135	1.135	1.136		
Y	1.565	1.585		1.575	1.574	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	07/11/18	Date:	07/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 	

DART AEROSPACE LTD			Work Order: <u>35227</u>
Description: 206 Saddle, Outboard, Right side		Part Number:	<u>D2932-2</u>
Inspection Dwg: D2932 Rev. C			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.122	.121		
B	0.100	0.140		.120	.120	.118	.119		
C	0.100	0.140		.118	.119	.118	.119		
D	0.210	0.230		.220	.2205	.221	.220		
E	1.245	1.255		1.200	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.495	2.497	2.497	2.497		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.122	.121	.123	.122		
O	0.540	0.560		.550	.550	.551	.551		
P	0.490	0.510		.509	.508	.509	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.492	2.493	2.495		
S	0.240	0.270		.254	.254	.254	.255		
T	0.100	0.180		.143	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.321	.321	.321		
X	1.125	1.145		1.1335	1.135	1.133	1.133		
Y	1.565	1.585		1.572	1.573	1.572	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD
Date: 02.16.17

Audited by: 8-5
Date: 02/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <u>SD</u>	<u>SD</u>

